

Work Order ID 101981

May-22-13 7:18:51 AM

*Black Smiley*

\*101981\*

Page 1

Item ID: D3913-041

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/06/13

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3913

B

D4020

A

100

Weld per dwg A/R S.S. rod Batch: *1128357* 0.00

Large Fab

\*100\*

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3913 using DT9610A

\*\*\*inspect before welding mesh\*\*\*

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913

\*\*\*take lid to locate hinge and bracket\*\*\*

4- Weld D4672-1 blanking plates as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

*CC / 13-05-24*

*13-05-27*

*DAS 09 8-09*

# Work Order ID 101981

\*101981\*

Page 2

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Item ID: D3913-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 6/06/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
<b>*125*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

13-05-27

09

16 B527

# Work Order ID 101981

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Item ID: D3913-041

Revision ID:

Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Start Qty: 1.00

**\*1\***

Required Date: 6/06/13

Req'd Qty: 1.00

**\*1\***

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

130

**\*130\***

Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref 4.3.5.2) per QS1005 4.3-Steel

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Memo

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 2:00

OVEN TEMPERATURE: 320

FINISH TIME: 2:30

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

140

**\*140\***

QC

Quality Control

QC3- Inspect Part Finish

Memo

IXP M-13/05/27

1 B-52A 1-34

M123480

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Item ID: D3913-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 6/06/13

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Assemble as per dwg

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

1  $\phi$  13-5-2A

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

13-5-28

1

170

Identify as per dwg & Stock Location: P-103-C-11

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

101980

1  $\phi$  13-5-2A

# Picklist Print

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Page 1

Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC  
IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	79.0000	6	6		13-5-27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		22							
				122800		22			6				
				ST351		4							
				12422		3							
				124858		1							
				ST512		53							
				122800		53							
AN960JD8 Washer	NAS1149DN8321	Purchased	No			150	Each	0.0000	2	2		13-5-27	
				125068					2				
D2581 Mounting Bracket		Manufactured	No			100	Each	66.0000	2	2		13-05-24	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	B98503-24				
				WA		10							
				98503		10							
				WA004		56							
				101383		20							
				70766		2							
				81253		1							
				82506		2							
				83230		3							
				85452		2							
				87706		2							
				99067		12							
				99837		12							

# Picklist Print

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Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No  
Bumper

150 Each 2,190.0000 2 2

BL 13-5-27

Location Loc Qty Loc Code

GA 192  
46064 192  
ST021 1998  
86435 1998

2

D3913-1 Manufactured No  
Rib

100 Each 2.0000

B 94721 13.05.24

Location Loc Qty Loc Code

WA005 2  
88637 2

D3913-15 Manufactured No  
Wide Handle Plate

100 Each 17.0000

B 100 417 13.05.24

Location Loc Qty Loc Code

WA003 12  
100417 12  
WA004 5  
97719 5

D3913-3 Manufactured No  
Rib

100 Each 7.0000

B 97973 13.05.24

Location Loc Qty Loc Code

WA004 5  
97728 2  
97973 3  
WA005 2  
69160 1  
84651 1

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Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

D3913-7 Manufactured No

100 Each 6.0000

<sup>2</sup> B 94 742 → 2x

13.05.24

Location

Loc Qty

Loc Code

WA004  
94742  
WA006  
98451

5  
5  
1  
1

D3913-9 Manufactured No

100 Each 5.0000

<sup>1</sup> B 97674 <sup>1</sup> 13.05.24

Location

Loc Qty

Loc Code

WA005  
70138  
97674  
97910

5  
1  
1  
3

D3916-041 Manufactured No

100 Each 8.0000

<sup>2</sup> B 97938 → 2x 13.05.24

Location

Loc Qty

Loc Code

WA004  
100358  
97938  
WA005  
81444

6  
1  
5  
2  
2

D3916-5 Manufactured No

100 Each 16.0000

<sup>3</sup> B 97725 → 3x 13.05.24

Location

Loc Qty

Loc Code

WA004  
94698  
97725  
WA005  
77142  
82933

11  
2  
9  
5  
1  
4

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Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

D4016-1 Manufactured No  
Hinge Half, Base

100 Each 52.0000

<sup>3</sup> B 97664 <sup>3</sup> → 3x

Location

Loc Qty

Loc Code

WA  
97664  
WA004  
100265  
WA005  
94481

11  
11  
30  
30  
11  
11

13.05.24

D4017-7 Manufactured No  
Rib

100 Each 7.0000

<sup>1</sup> B 94149 13.05.24

Location

Loc Qty

Loc Code

WA004  
94149  
WA005  
69730  
82969  
85435  
88392

3  
3  
4  
1  
1  
1  
1

D4017-9 Manufactured No  
Rib

100 Each 7.0000

<sup>2</sup> B 98002 <sup>2</sup> → 2x

Location

Loc Qty

Loc Code

WA004  
98002  
WA005  
70341  
81445

4  
4  
3  
2  
1

13.05.24

D4020-11 Manufactured No  
End Mesh, Basket

100 Each 11.0000

<sup>2</sup> B 100650 13.05.24

Location

Loc Qty

Loc Code

WA007  
100650  
81442  
84972

11  
8  
2  
1

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Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350.

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

D4021-1  
Handle Plate

Manufactured No

100 Each 81.0000

<sup>3</sup> B100649 <sup>3</sup> → 3x

Location	Loc Qty	Loc Code
WA004	81	
100366	54	
100649	19	
89204	3	
94596	3	
97940	2	

13-05-24

D4021-5  
Blanking Plate

Manufactured No

150 Each 10.0000

2 2

Location	Loc Qty	Loc Code
ST084	10	
85065	2	
98260	8	

102115.

2

12 B-507.

D4034-041  
Aft Upper Rib Assembly

Manufactured No

100 Each 5.0000

<sup>1</sup> B94813 <sup>1</sup> 13-05-24

Location	Loc Qty	Loc Code
WA004	4	
94813	3	
94977	1	
WA005	1	
84048	1	

D4034-043  
Fwd Upper Rib Assembly

Manufactured No

100 Each 5.0000

<sup>1</sup> B99595 <sup>1</sup>

Location	Loc Qty	Loc Code
WA004	3	
100286	1	
99595	2	
WA005	2	
82980	2	

13-05-24

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Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

D4672-1  
Blanking Plate

Manufactured No

100 Each 22.0000

2

2

B 101186 → 2x

13.05.24

## Location

## Loc Qty

## Loc Code

WA004

18

101186

18

WA005

4

88253

4

M304EX0.75-16F  
Expanded Metal Flat SS

Purchased No

100 sf 1,355.8151

33

33

1125457 → 33

13.05.24

## Location

## Loc Qty

## Loc Code

MAT

176.2791180

125113

176.279118

WA

447

125457

447

WA007

732.536

123448

15.96

125457

236.576

125605

480

MS20600-AD4W3  
Cherry Rivets

Purchased No

150 Each 1,121.0000

2

2

BR B-52A

## Location

## Loc Qty

## Loc Code

ST311

988

122151

4

122452

4

123525

294

124231

686

WA003

133

107939

133

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Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

3,595.0000

6

6

BL B-5-27

Nut

## Location

## Loc Qty

## Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

3306

123900

954

124291

2352

6

NAS1149F0332P

Purchased

No

150

Each

13,046.000

12

12

BL B-5-27

WASHER

## Location

## Loc Qty

## Loc Code

GA

182

122063

182

ST294

158

122063

158

ST295

3

123352

3

st510

7703

123900

7703

12

ST510a

5000

125646

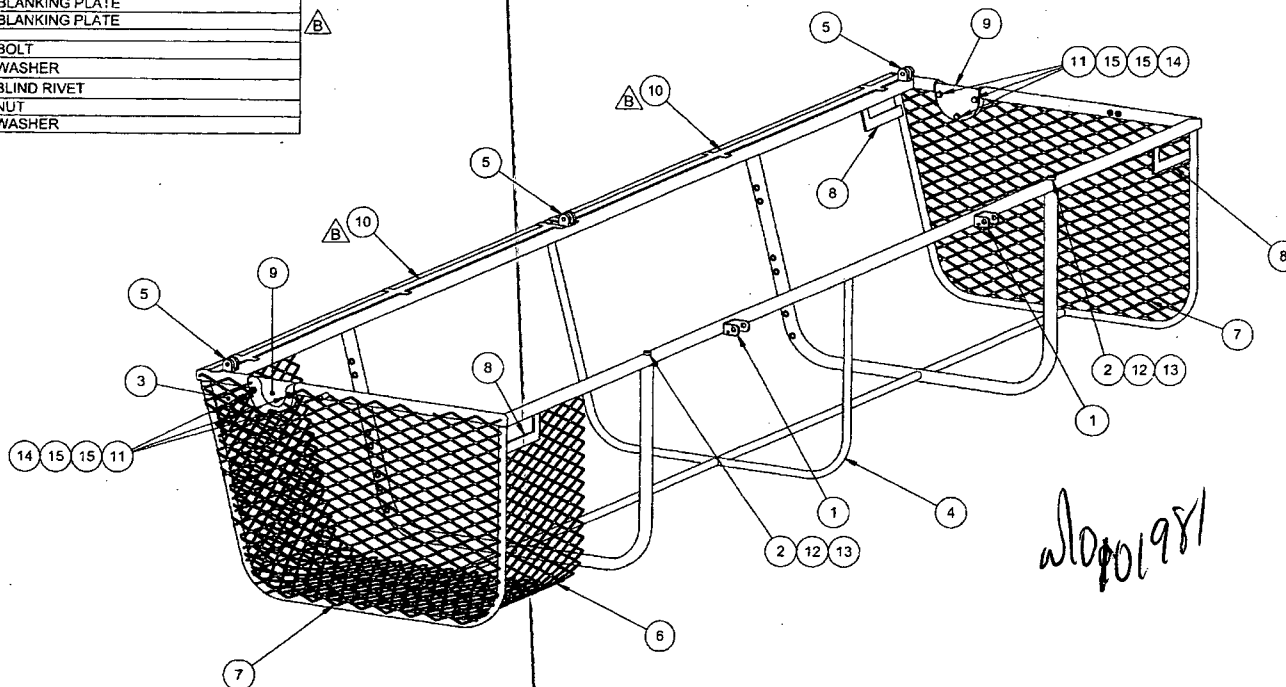
5000

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Shop Packet Print

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

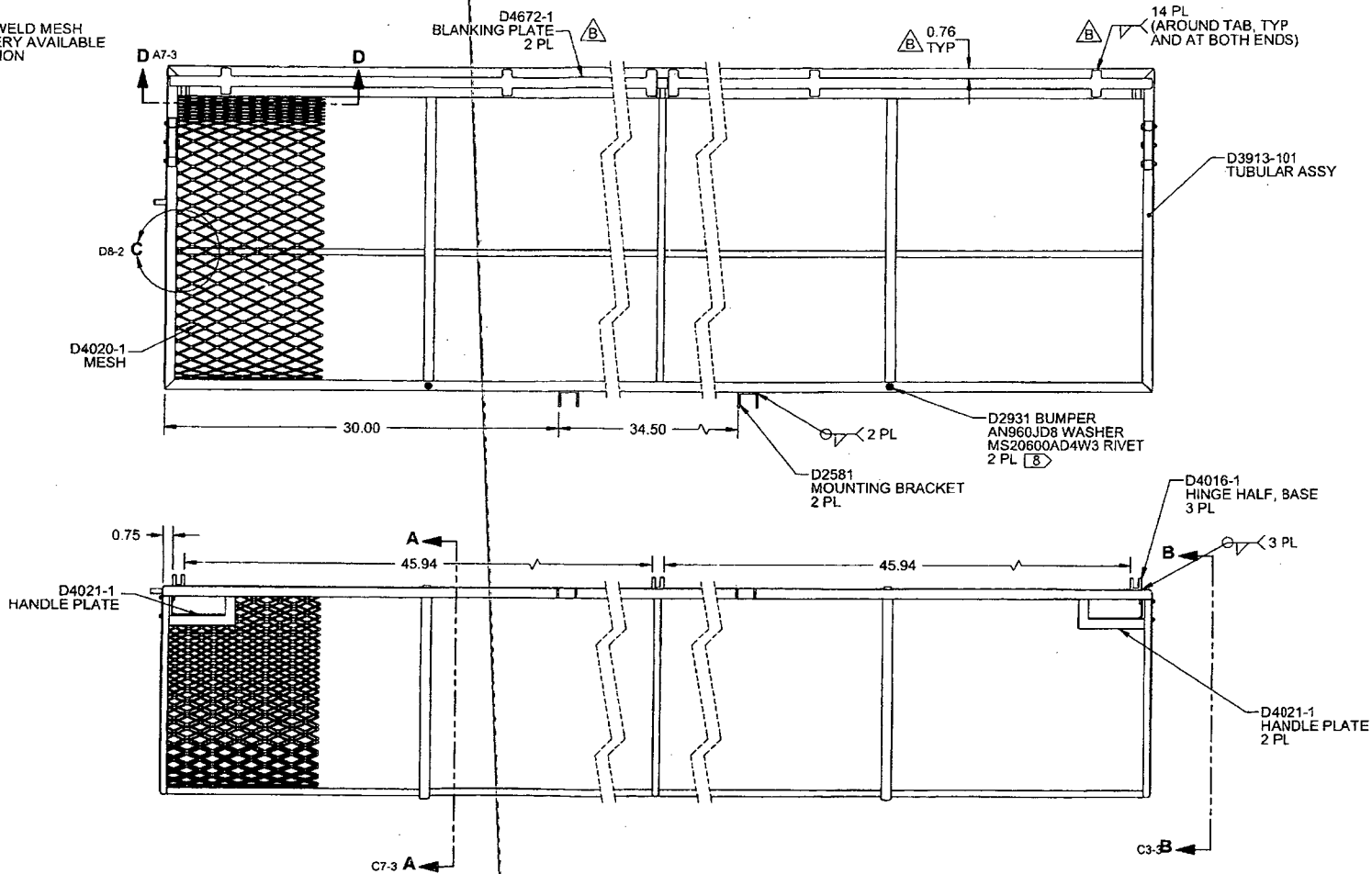
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2012-07-12  
ECN 12-60

B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP	DRAWING NO.	REV. B
CHECKED		D3913	SHEET 1 OF 6
MFG. APPR.		TITLE	SCALE
APPROVED		<b>LONG BASKET BASE ASSY (350) NTS</b>	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.06.15		

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

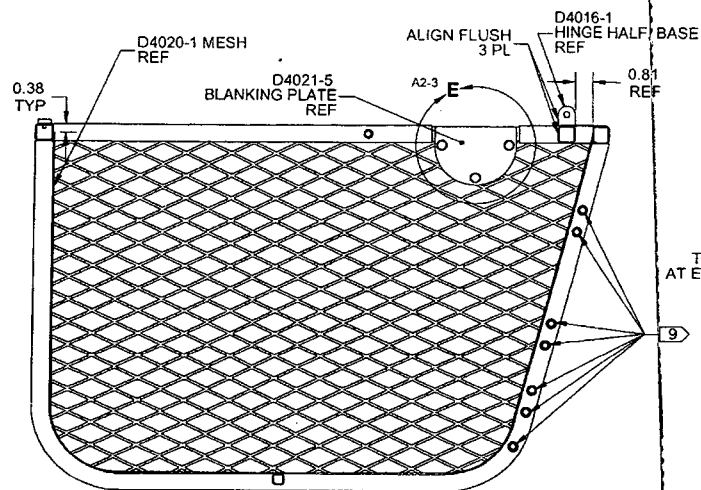
DETAIL C D7-2



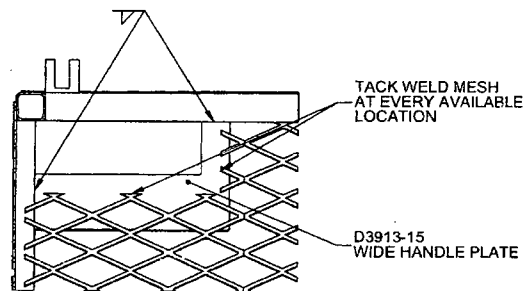
**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
2012-07-12

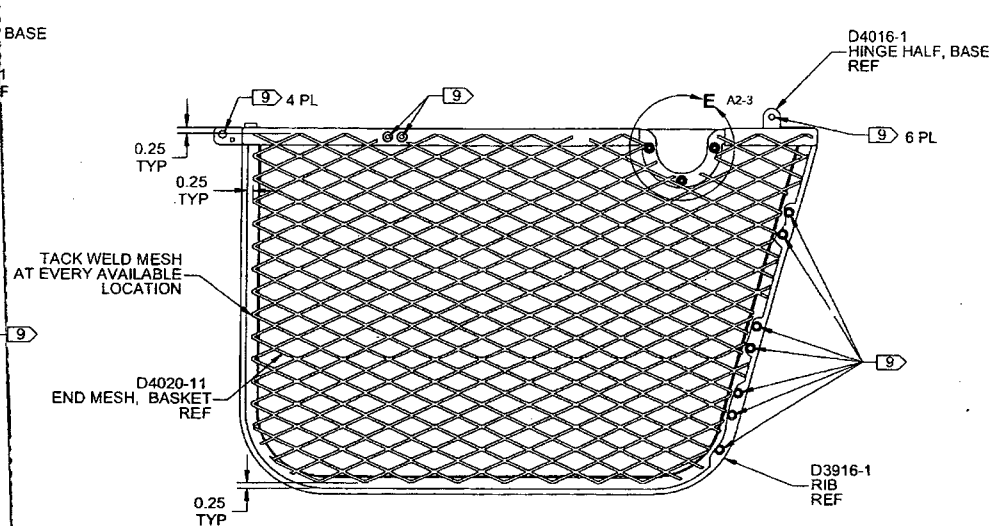
DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D3913	SHEET 2 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	<b>LONG BASKET BASE ASSY (350) NTS</b>	
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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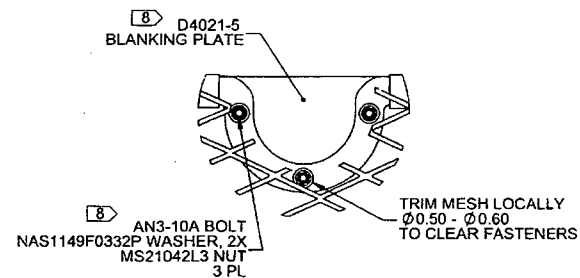
**SECTION A-A** A5-2



**SECTION D-D** D6-2  
TYPICAL FOR ALL  
HANDLE PLATES



**VIEW B-B** A2-2

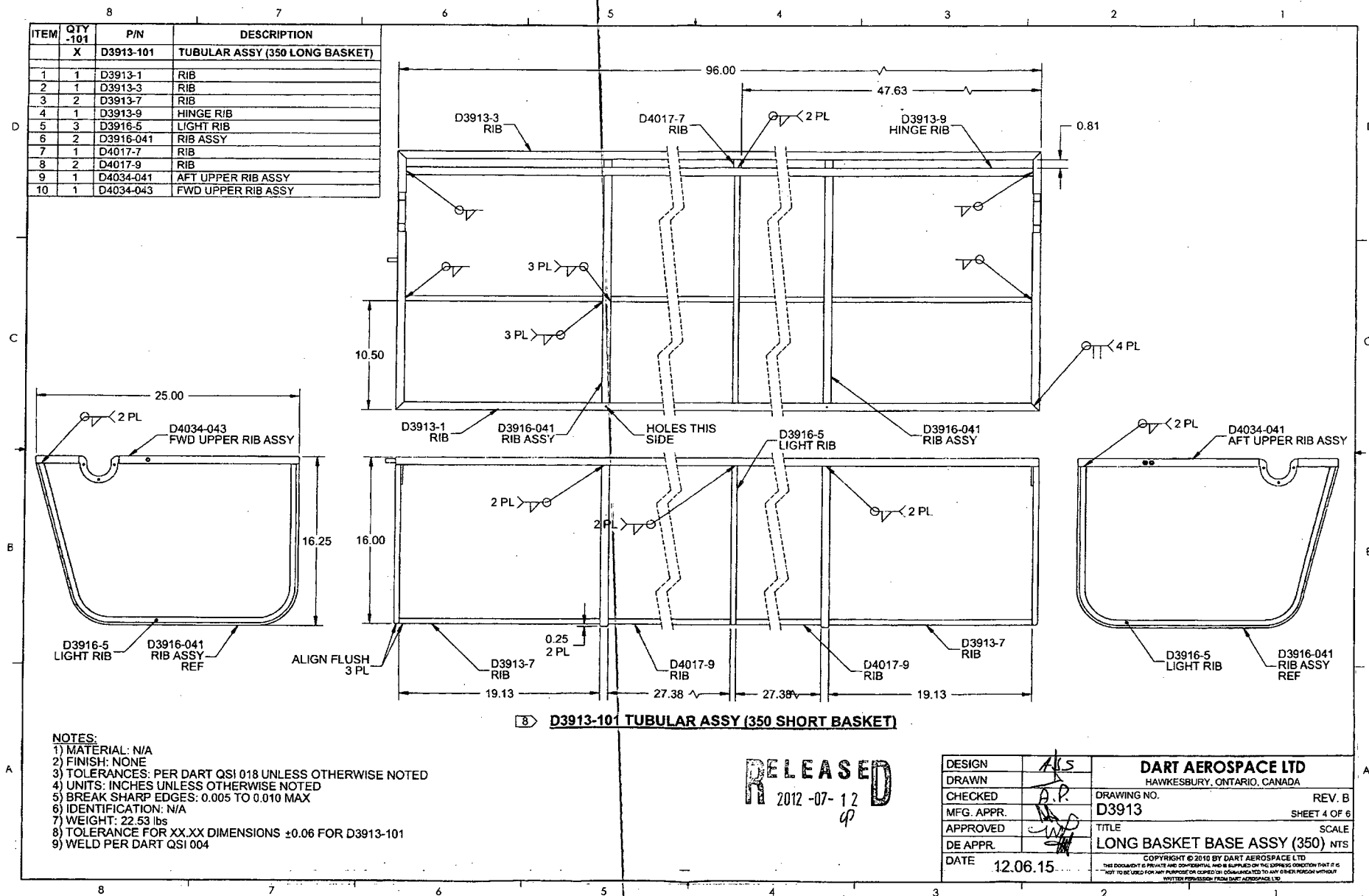


**DETAIL E** D2-3  
D6-3

**RELEASED**  
2012-07-12  
UP

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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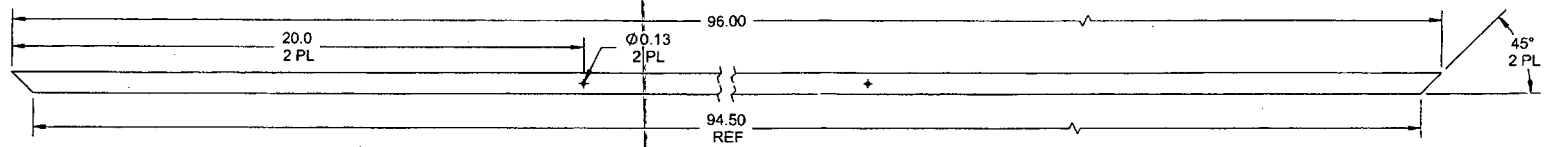
ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



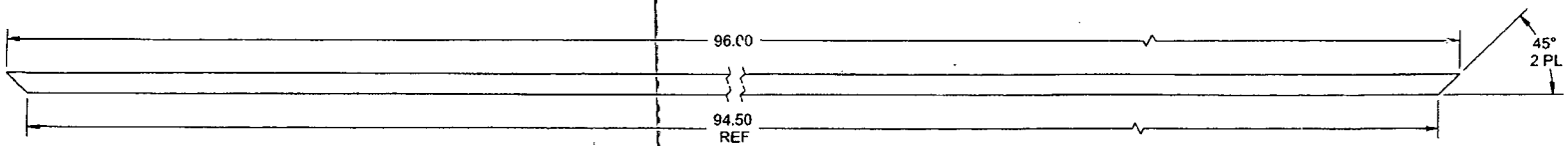
RELEASED  
2012-07-12  
4

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A.P.	DRAWING NO. D3913	REV. B
CHECKED			SHEET 4 OF 6
MFG. APPR.		TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CLIPED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DE APPR.		DATE 12.06.15	

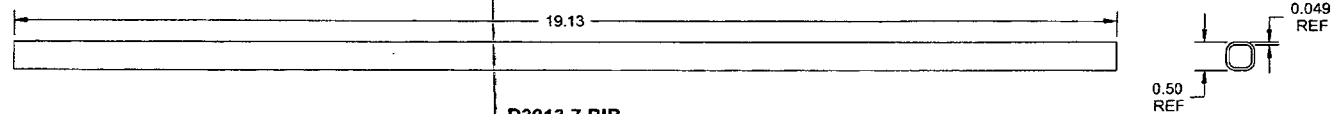
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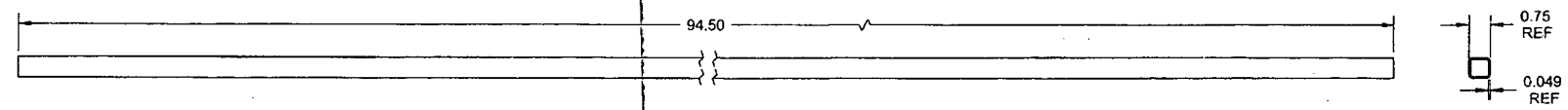
**D3913-1 RIB**



**D3913-3 RIB**



**D3913-7 RIB**



**D3913-9 HINGE RIB**

**NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL.  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.750W.049

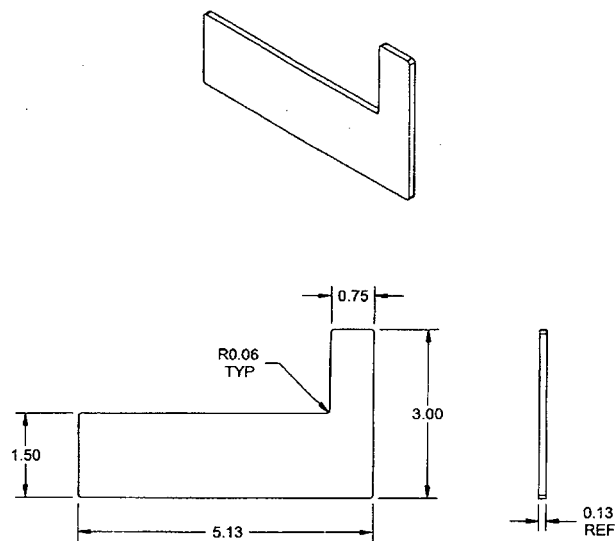
-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
PER ASTM A554 OR ASTM A269 MILL FINISH  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3913</b>	REV. B
MFG. APPR.		SHEET 5 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350) NTS</b>	
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8 7 6 5 4 3 2 1



**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	3	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P.V.	DRAWING NO.	REV. B
MFG. APPR.	11	<b>D3913</b>	SHEET 6 OF 6
APPROVED	11	TITLE	SCALE
DE APPR.	11	<b>LONG BASKET BASE ASSY (350) NTS</b>	
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